

# Work Order ID 62688

Wednesday, October 06, 2010 10:52:54 AM



Page 1

Item ID: D2739

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 I Beam

Start Date: 10/6/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-10-06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2739	Rev D E								
100	Skidtubes	0.00							
	Skidtubes								
	Skidtubes								
	Memo	0.00							
	1-Cut D2600-5 to length as per Dwg D2739. ✓								
	2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739								
	3-Use uni-bit to open holes to finish size as per Dwg D2739.								
	4-Beyel Fwd end of extrusion and Deburr holes and ends.								
	5-Dburr								
120	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish								
	Hand Finishing								
	Memo	0.00							

BB 10/11/03  
PTO

BB 10/11/03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
<del>10/11/03</del>	<del>100</del>	<del>BEVEL BOTH ENDS ON 1 WEB.</del>	<del>BB</del>	<del>10/11/03</del>	<del>1</del>			

Part No: D2739 PAR #: N/A Fault Category: Skid tubes NCR: Yes No DQA: ls Date: 10.11.08  
 Resolution: re-work Disposition: re-work QA: N/C Closed: ls Date: 6/11/08

NCR: 62688		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/03	100	BEVEL WORK END OF WEB (1) R.C. Lack of Attention	CP 10.11.03 05/042	BEVELED BOTH ENDS (1)	BB 10/11/03	S 10/11/03	CP 10.11.03 05/042	S 10/11/03

NOTE: Date & initial all entries

**Work Order ID 62688**

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Item ID: D2739

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 I Beam

Start Date: 10/6/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
140  Packaging Packaging	Identify as per dwg & Stock Location: <u>LE</u>  Memo	0.00 0.00							 10/11/03
150  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							 10/11/03  MK 10-11-3

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 62688



Parent Item: D2739



Parent Item Name: 350 I Beam


Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev: C 02.11.28 Reformat KJ  
IPP Rev: D 06-03-21 As Per Rev C JLM  
IPP Rev: E 07-07-28 As per Rev D JLM Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108  Extrusion 'I Beam' thin		Manufactured	No			100	Each	149.0000	1	8			



SAD

10-11-02

Location

Loc Qty

Loc Code

LG

149

47814

149

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

1/2

DART AEROSPACE LTD		Work Order: 62688
Description: 350 <i>Alid I-Broom 3g</i>		Part Number: D2739
Inspection Dwg: <i>DT 8162</i> D2739 Rev: <i>E</i>		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

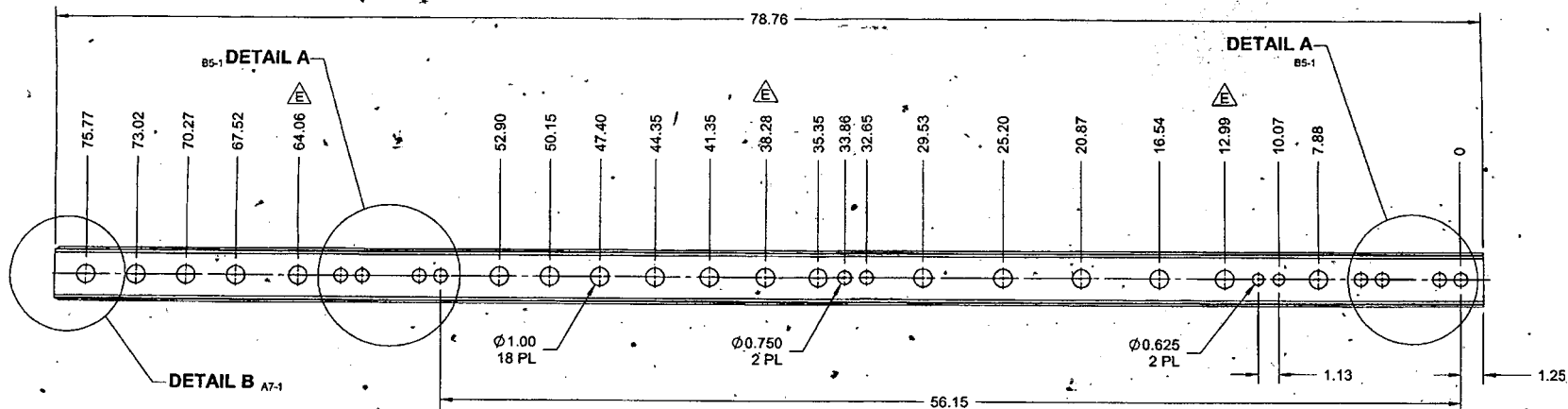
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
78.26	$\pm 0.030$	78.26	✓		DP-4 Tape	MEASUR
Detail A					✓	
1.180	$\pm 0.010$	1.180	✓		✓	
3.150	"	3.150	✓		✓	
1.180	"	1.180	✓		✓	
Detail B					✓	
0.25	$\pm 0.030$	0.25	✓		✓	
30°	$\pm 1/2^\circ$	30°	✓		✓	
					✓	
1.25	$\pm 0.030$	1.27	✓		✓	
7.88	"	7.88	✓		✓	
10.07	"	10.07	✓		✓	
12.99	"	12.99	✓		✓	
16.54	"	16.54	✓		✓	
20.87	"	20.87	✓		✓	
25.20	"	25.20	✓		✓	
29.53	"	29.53	✓		✓	
32.65	"	32.65	✓		✓	
33.86	"	33.86	✓		✓	
35.35	"	35.35	✓		✓	
38.28	"	38.30	✓		✓	
41.35	"	41.35	✓		✓	

Measured by: <i>DP</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: 10-10-2	Date: 10/14/03	Date:	N/A

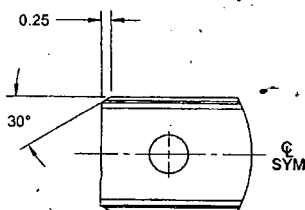
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



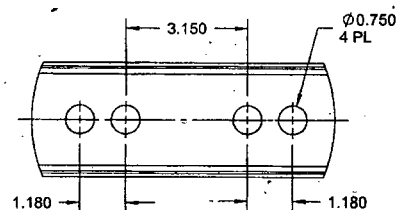




**D2739 WEB**



**DETAIL B**  
SCALE 3X



**DETAIL A**  
SCALE 3X

**NOTES:**

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 3.41 lbs

*u/o 62688*

**RELEASED**  
2010-11-01

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (D5-1), 64.06 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CS	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D2739</b> TITLE <b>WEB</b>	
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP	REV. E SHEET 1 OF 1 SCALE NTS	
DATE	10.10.08	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

